

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010952**Date Inspected:** 05-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

6CW+6BW

Flux Core Arc Welding (FCAW) welding was performed on weld joints 20 and 22 located at BP033-001. Welder is identified as Mr. Fan Chenfu (067501). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 004 located at OBW6C. Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

6CE

Flux Core Arc Welding (FCAW) welding was performed on weld joints 001~008 located at SSD27-PP045. Welder is identified as Mr. Wang Yuli (068858). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2133 and WPS-B-T-2132.

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5BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 007 located at CA020 bike path side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-Smaw-2G (2F)-Repair-1 and WR8552.

6CW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 044 located at SSD25-PP045. Welder is identified as Mr. Wei Dashuai (053742). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T.

Flux Core Arc Welding (FCAW) welding was performed on weld joints 114 and 105 located at SEG031H. Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

Flux Core Arc Welding (FCAW) welding was performed on weld joints 042 and 096 located at SEG031H. Welder is identified as Mr. Yu Huiye (045143). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

NDT Observation

This QA Inspector observed ZPMC's Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Y location and indications are as followed:

6AE+6BE

1. Deck plate weld joint OBW6-003 repair areas.

This QA Inspector observed ABF's Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Y location and indications are as followed:

1. Entire edge plate to deck plate weld joint on bike path side of segment.

6BW

During random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered repair was performed on weld joint SEG24\*-037 without a CWR present nor prior approval from the Engineer. Be advised the note area was inspected by ZPMC Magnetic Particle (MT) technician on 1-04-10 and observed 3 transverse indications present at the time of inspection. This QA Inspector issued an incident report for this issue.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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